

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011832**Date Inspected:** 17-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA.	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG.	

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

For Cross Beams (CB):

Bay 3: CB14.

This QA inspector observed ZPMC performing the grinding of the weld profile at the time when this QA was present.

Bay6: CB9.

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Outside Yard:

CB13:

This QA inspector observed ZPMC QC & ABF QC performing the Visual Inspection of various weld joints at the time when this QA was present.

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## WELDING INSPECTION REPORT

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### CB16:

During inprocess visual inspection of CB16, this QA Inspector observed that the Bottom Panel of this CB is distorted due to welding. This distortion was measured and was observed as approximately 15mm per 1000mm (at North side of Bottom panel) and approximately 25mm per 1000mm (at South side os the Bottom Panel). This QA Inspector then discussed this issue with ZPMC QC Mr. Zhong Wei. ZPMC QC was found to be aware of this problem and agreed that this will be rectified with proper documentation (with Engineers approval). The Bottom Panel of CB is designated as Seismic Performance Critical Member (SPCM).

### CB8, CB11, CB10, CB15, CB7 & CB12:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

### Trial Assembly: CB4, CB5 & CB6.

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall,Steven
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QA Reviewer
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